<b>Work Order ID</b> June-24-13 1:59:02 Pi			1	*10	3597*					Page 1	· · · · · · · · · · · · · · · · · · ·
Revision ID: / Revision ID: / Item Name: Mount Start Date: 6/24/1 Required Date: 7/05/1 Reference:	ing Plate  3 Start Qty	//	1 Dec	Accept	*N900  Cust Item I  Customer:			Setup Start	*N:	S1* S2*	
Approvals: Proc	ess Plan: MU	<u> </u>	Date: 13-06-25	Tooling:	D	ate:		Run Star	1/1	R1*	
QC:		· ·	Date:	SPC (Y/N):	D	ate:	·	Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description			Set Up/ Run Hours	Tool ID	Tool # Pla		Reject Qty	Reject Number	Insp. Stamp	_
Draw Nbr D2957	Revision Nbr Rev B	·									
100 * 100* Bandsaw	BAND SAW			0.00	02/1H	13/07/21	15	<b>(3)</b>			
Jeaspa Bandsaw		Memo Cut blanks 10.5 1 blank makes		0.00			,			7	. Prince
110.	HAAS CNC	VERTICAL M	ACHINING #1	0.00	only	,	<b>4%</b> (			- <u>:</u>	
*110* HAAS 1 HAAS CNC vertical machin		Memo Machine as per Deburr		0.00	OZMH 13	107/21	<del></del>			-	1*
120	QC2- Inspec	et parts off mach	nine FAI/FAIB	0.00	7 <u> </u>			****		· · · · · · · · · · · · · · · · · · ·	
*120* QC Quality Control		Memo		0.00	m/MH 13/00	7/21					

DQA: Date:			- Wary apper Nav Careans (Upp 17)									
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF		Vork Order u <u>r</u>	odate only	AEROSPACE
Work Orde	ır.				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
WOIR Olde				-	Rework	1 <b> </b>		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	lo			_	Scrap			Machining	Small Fab	<del>-</del>	d. Eng. Coor.	Quality
NCR No.			_	Use-as-is Suspected Unapproved		Thermoforming Finishing  Large Fab Composite			Rec/Stor	re/Packaging Supplier	Other	
Root				Descr	iption of work order update		nitial	Acti	ion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre					•	1						
Material												
Operator			1									
Offset/Setup										1		
Process												
Supplier												
Training												
Transport												
Unapproved	_											
						FAI	ULT CA	TEGORY			<del></del>	
Landi	ng Gear				General		_			<u></u>		
	Bendin	3			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced
	Centre	Not Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct [	Temperature/Cure
	Crimp/Kink/Ripple/Wave			Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	ssing	Weld	
	Cuffs			Contamination	Г	Instruc	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled	
	Crushin	g			Countersink		Misali	gned/off center		Positioned V		
	Heat Treat			Cut Too Short		Mislab	eled	Γ	Power Loss/	Surge	Other	
	Inspect	ion Strip in	Tube		Drawing		Misrea	d	_	<del></del>	_	
	Marks/	Chatter			Drill Holes		Off-set			·		· · · · · · · · · · · · · · · · · · ·
	Turning	Sequence			Finish		Out of	Calibration				
	Wave/1	wist in Tul	be		Fit/Function		Out of	Sequence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Orde June-24-13 1:59		3597		*103	3597*						Page 2	
Item ID: Revision ID:	D2957			Accept	*N900	<b>1040</b>	100	)* s	etup Star	I VI	S1*	
Item Name:	Mounting Plat	e							Stop	, *N	S2*	
en <b>eng</b> an (1)	6/24/13	<b>Start Qty: 12.00</b>	*12*		Cust Item	ı ID:						
Required Date: Reference:	7/05/13	Req'd Qty: 12.00	*12*	<b>k</b>	Customer	r:						
Approvals:	Process Pla	n:	Date:	Tooling:		Date:	_	F	tun Star	* *N	R1*	
			Date:			Date:			Stop	` *N	R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
130		QC8- Inspect parts - secon	nd check	0.00								
*130*		Memo		0.00				15			113-92	
Quality Control									٠			
150		Identify as per dwg & Sto	ck Location: WHO	⊃C( <sub>0.00</sub>								
*150*								$\sqrt{5}$	·		$\odot$	
Packaging Packaging		Memo *****STOCE	K IN BASKET CELL**	0.00				(			137-1	$\supseteq$
* ,											J. J.	
160		QC21- Final Inspection -	Work Order Release	0.00						13/	7/24/	1
*/1 60* QC Quality Control		Memo		0.00						· / /		ر ا

DQA: Date:			DART												
QA Closed:			Date:			WORK ORDER NON	N-C(	ONFO	RMANCE / UF	PDATE	\٨/،	ork Order up	ndate only		AEROSPACE
						DISDOSITION						•			
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
		•			_	Rework	7		Skid-tube	Crosstube			Water Jet		Engineering
Part N	No					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging		Other
NCR I	No					Suspected Unapproved	J		Large Fab	Composite			Supplier		
Root					Descr	ription of work order update		Initial	Acti	ion		Sign &			
Cause		ate	Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption		Date	Verification	,	QC Inspector
Design															
Doc/Data													•		
Equip/Tooling	Щ														
Handling/Pre	Щ														•
Material		:												ŀ	
Operator															
Offset/Setup	$\vdash$														
Process	$\vdash$														
Supplier	H														
Training Transport	$\vdash$														
Unapproved	$\vdash$														
onapproved	!						ΕΛ	IIIT CAT	I TEGORY	-		<u> </u>		L	
Landi	ng Gear					General	17	OLI CA	ILGORI	<del></del>					
		nding				Bend		] Folio/P	rogram			Outside Dim	ensions [	٦,	Pressure/Forced
	Cer	itre No	t Concen	ntric	Н	BOM/Route	$\vdash$	Grain			H	Over/Under	<b>5</b> -		Set-up
	Cra	cks				Broken/Damage/Defect		Hardwa	re			Part Incorred	<b>⊢</b>	_	Temperature/Cure
	Crir	np/Kinl	k/Ripple,	/Wave		Burrs		1	ion Incomplete/Un	qualified		Part Lost/Mi	<b>⊢</b>	_	Weld
	Cuffs				Contamination		1	ions Incomplete/U	·		Part Moved	· · ·		Wrong Stock Pulled	
	Crushing				Countersink		4	ned/off center			Positioned V	_		3	
	Heat Treat				Cut Too Short		Mislabe	eled			Power Loss/:	Surge	$\neg$	Other	
	Ins	pection	Strip in	Tube		Drawing		Misread	d			•	L		
	<u></u> Ма	rks/Cha	atter			Drill Holes		Off-set							
			quence		_	Finish		Out of 0	Calibration						
	Wave/Twist in Tube				Fit/Function		Out of 9	Sequence							

Page 1

Work Order ID:

103597

Pårent Item:

D2957

Parent Item Name:

Mounting Plate

**Start Date:** 6/24/13

Required Date: 7/05/13

Start Qty: 12.00

Required Qty: 12.00

Comments:	IPP: C00.08.09N	lew dwg rev B (m	pp 2078)I	EC									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin : Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X01.250 6061-T6 Bar .500 x 1.25	. : .	Purchased	No			100	f	18.7500	0.175	2.210526			
		•		<b>Location</b>		Loc Qty	Lo	c Code					
				MAT001		18.75					A ()		
				- 1225	21	18.75			<u> </u>	<u> </u>	MH 13	3/07/2	1

DQA: Date:			ĎΔRT												
QA Closed:			Date:			WORK ORDER NON-	-C(	ONFO	RMANCE / U		Wor	k Order up	odate only	$\neg$	AEROSPACE
Work Orde	or.					DISPOSITION						ARTMENT,	· · · · · · · · · · · · · · · · · · ·		
WOIR OIGE	-'-				-	Rework	1		Skid-tube	Crosstube	$\neg$		Water Jet	$\neg$	Engineering
Part N	No.					Scrap	1 1		Machining	Small Fab		Pro	d. Eng. Coor.	-	Quality
	_					Use-as-is	1 1		noforming	Finishing	$\dashv$		e/Packaging	$\dashv$	Other
NCR N	No					Suspected Unapproved			Large Fab	Composite	_		Supplier		
Root	1	_		,	Desci	ription of work order update		Initial	Act	tion		Sign &		$\top$	
Cause		Date	Step	Qty	,	or non-conformance	1	ief Eng		ription		Date	Verification		QC Inspector
Design			•		····		T	· · · · · · · · · · · ·							
Doc/Data															
Equip/Tooling									•					l	
Handling/Pre						•									
Material		:												-	
Operator												,		-	
Offset/Setup															
Process															
Supplier															
Training															
Transport															
Unapproved													!	ļ	
							FA	ULT CA	TEGORY						
Landi	ng Ge	ar				General		_							
	В	ending				Bend		Folio/F	Program			Dutside Dim	ensions [	F	Pressure/Forced
		entre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
		racks				Broken/Damage/Defect		Hardwa	are		F	Part Incorred	it [		Temperature/Cure
		rimp/Kir	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	F	art Lost/Mi	ssing	\	Weld
		uffs				Contamination		Instruc	tions Incomplete/l	Jnclear	F	Part Moved		\	Wrong Stock Pulled
		rushing				Countersink		Misali	gned/off center		F	ositioned V			
	Heat Treat			Cut Too Short		Mislabe	eled			Power Loss/:	Surge		Other		
	∐ ir	spection	n Strip in	Tube		Drawing		Misrea	d	•					
	Шм	1arks/Ch	atter			Drill Holes		Off-set			_				
	Шт	urning S	equence			Finish		Out of	Calibration		_				
				Fit/Function		Out of	Sanuanca		_						

DART AEROSPACE LTD	Work Order:	103597
Description: Mounting Plate	Part Number:	D2957
Inspection Dwg: D2957 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Art	cle	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension	•		Inspection	
0.25	+/-0.030	.247	J			
0.068	+/-0.010	-07 IS	J			
Ø0.323	+/-0.010	-315	J			
0.250	+/-0.010	.247	J			
1.06	+/-0.030	1-0655	J			
0.875	+/-0.010	.875	1			
0.449	+/-0.010	.441	1			
R0.12	+/-0.030	-13	1			
1.85	+/-0.030	1.851	J			<del>- 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1</del>
0.250	+/-0.010	. 251	$\sqrt{}$			
0.19	+/-0.030	-120	J			
0.125	+/-0.010	-127	J			
		·				
				-		

Measured by:	MH/ON	Audited by:	·	Prototype Approval:	N/A
Date:	13/07/21	Date: 13-7-20		Date:	N/A

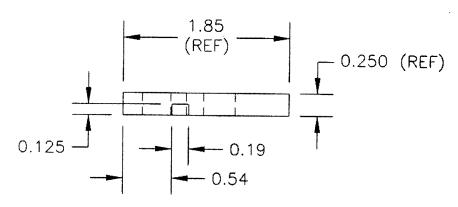
Rev	Date	Change	Revised	Approved
Α	04.04.20	New Issue	KJ/RF	- 4

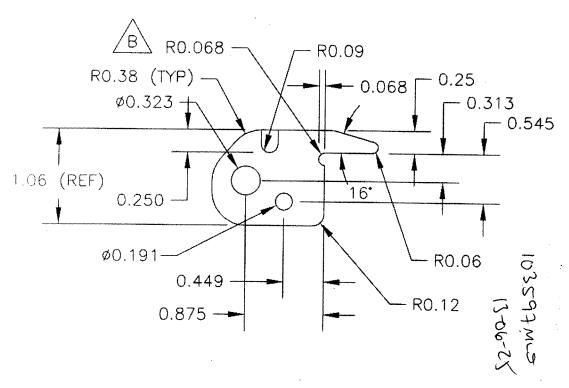




	RF	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KEDM	APPROVED	DRAWING NO. REV. B
	7111	#	D2957 SHEET 1 OF 1
DATE			TITLE SCALE
 00.0	7.06		MOUNTING PLATE 1:1
Α		00.01.20	NEW ISSUE
В		00.07.06	MODIFY CORNER DETAIL

ELFASE (00 07.18 #





MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11) 0.250 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED BREAK ALL SHARP EDGES 0.010 TO 0.020

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